



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3492-5
Job Sheet 183384



Part No: D3492-5

Job Qty: 60 ea

Part Name: Plug



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/17/18

Job Tracking No:

Due Date: 10/5/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea	10/5/18	10/5/18	0.00	0.00	Start Up Machining-2		11/8/18
100	Hardinge	60 pcs	10/5/18	10/5/18	0.00	2.43	Hardinge		11/8/18
110	QC	60 pcs	10/5/18	10/5/18	0.00	0.00	QC2 Machining-2		11/8/18
120	QC	60 pcs	10/5/18	10/5/18	0.00	0.00	QC8 Machining-2		11/8/18
150	HandFinish	60 pcs	10/5/18	10/5/18	0.00	0.21	HandFinish1		11/8/18
160	Powdercoat	60 pcs	10/5/18	10/5/18	0.00	0.09	Powdercoat1		11/8/18
170	QC	60 pcs	10/5/18	10/5/18	0.00	0.00	QC3		11/8/18
180	Packaging	60 pcs	10/5/18	10/5/18	0.00	0.00	Packaging3-1	FP-001	11/8/18
190	QC21-SA	60 Ea	10/5/18	10/5/18	0.00	0.00	QC21		11/8/18

Part Op 100 - 1-Turn as per Folio FA634 & Dwg D3492
Descriptions: 160 - (Flat End Only) START TIME: 11:50 FINISH TIME: 12:15 O.V.T. 300 M138951
180 - LOCATION : FP001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R0.375	6061-T6 Round Bar .375"	3.6000 ft (.06 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R0.375	4	23	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Plug	0.375inches $\pm$ 0.010	0.385 0.365		
2	Plug	0.188inches + 0.005 - 0.001	0.193 0.187		
3	Plug	0.045inches + 0.000 - 0.002	0.045 0.043		
4	Plug	0.500inches $\pm$ 0.010	0.510 0.490		
5	Plug	0.060inches $\pm$ 0.005	0.065		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

			0.055
6	Plug	0.060inches $\pm$ 0.005	0.065 0.055
7	Plug	0.090inches $\begin{matrix} + 0.000 \\ - 0.002 \end{matrix}$	0.090 0.088

Plex 9/17/18 11:15 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS Part: D3492-5 Job No: 183384 Serial No/Batch: S124637 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/05/18 Container No: S124637 Part: D3492-5 Job No: 183384 Serial No/Batch: S124637 Water Jet ☐ Engineering ☐ Prod. Eng. Coord. ☐ Quality ☐ Rec/Store/Packaging ☐ Other ☐ Supplier ☐ MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
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